

Proposed Amendments to the Claims:

The listing of claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims:

Claim 1 (currently amended): A method for the manufacture of a cam shaft from a tube having the cam shaft having non-hollow cam regions, and hollow cam regions formed on the tube at positions where bearer rings are attached thereto, the method comprising the following steps:

placing bearer rings, produced in a separate method and in correspondence with prospective locations of hollow cam regions on said cam shaft, in a high internal pressure forming tool together with the tube to be formed ~~and subjected to the action of axial forces and a medium under high internal pressure, whereby the bearer rings are attached by expansion of the tube in a frictional and interlocking manner, each of the bearer rings having an outer surface and an inner surface and the necessary hardness, strength and wear resistance, the radial thickness between the outer and inner surfaces being equal completely around the tube;~~

subjecting the tube to axial forces and a medium under high internal pressure so that the tube expands to form said hollow cam regions, wherein the diameter of the tube in said region are greater than the diameter of the tube at the non-hollow cam regions; and

in a first method step prior to said high internal pressure forming, regions of the tube which are clear of the regions in which the cams are seated are so kneaded and/or upset such that said tube regions which are clear of the cam regions are increased in thickness and/or are stretched so that to form bearing faces, drive and/or control elements are formed from the tube itself, whereby the shaft has all cams in form and in position on a single piece.

Claims 2 (canceled)

Claim 3 (previously presented): The method as set forth in claim 1, characterized in that between the cam shaft ends in a step prior to internal high

pressure forming bearing faces and the eventual region where the cams are to be seated, are produced by round kneading and by reducing the diameter in this part to the desired size.

Claim 4 (previously presented) The method as set forth in claim 1 characterized in that bearing faces are produced between the cams by internal high pressure forming by expanding the tube.

Claim 5 (previously presented): The method as set forth in claim 1, characterized in that the bearer rings are hardened in a known manner prior to being placed in the internal high pressure forming tool.

Claims 6 - 18 (canceled)

Claim 19 (currently amended) ~~The method as set forth in claim 1, wherein the cam shaft has two ends, wherein one of said ends is formed closed by the kneading process prior to high internal pressure forming.~~ The method as set forth in claim 1, wherein the diameter of bearer rings have wall thickness which are not constant.